

SHI TODAY - EDWARDS - NCL09-099

Work Order ID 53004

October 21, 2009 7:20:15 AM



Page 1

Item ID: D3136-041

Accept



Setup

Start



Revision ID: E

Stop



Item Name: Window Assembly

Start Date: 10/21/09 Start Qty: 6.00



Cust Item ID:

Required Date: 10/21/09 Req'd Qty: 6.00

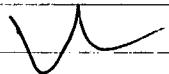


Customer:

Reference:

Approvals:

Process Plan:



Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr	Revision Nbr
D3136	Rev E

100

0.00



FLOW WATER JET

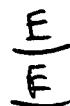
Waterjet

Memo

0.00

89-10-21

FLOW CNC Waterjet



110

QC2- Inspect parts off machine FAI/FAIB

0.00



Memo

0.00

89-10-21

QC

Quality Control

120

QC8- Inspect parts - second check

0.00



Memo

0.00

20/10/21



QC

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 53004

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Cust Item ID:



Customer:

Reference:

Approvals:	Process Plan:	Date:	Tooling:	Date:
	QC:	Date:	SPC (Y/N):	Date:

Run Start



Stop

Sequence ID/
Work Center ID

130



Thermoform

Thermoforming Machine

Operation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

0.00

THERMOFORMING MACHINE

Memo

0.00

1-Thermoform as per Dwg D3136 and Folio FTA006
 Rev. E Folio Rev. E 02-Engrave Part # and
 Batch # , and affix labels (D3136-1) B34554

140



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

0.00

150



QC

Quality Control

QC8- Inspect parts - second check

0.00

Memo

0.00

B34554
X6
B34554
X6
6
10/21/09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Work Order ID 53004

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Cust Item ID:

Required Date: 10/21/09 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

**Sequence ID/
Work Center ID****Operation
Description**Set Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160



HAND FINISHING THERMOFORMING

Thermoform

Memo

0.00

Thermoforming Machine

Water sand and buff to remove scratches as required

*BB Oct 10/21
XG*

170



QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

6 10/21

180



Identify as per dwg & Stock Location: _____

0.00

Packaging

Memo

Packaging

*Wrap in plastic
before flush.*

0.00

9/10/21 CX 80

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer:

Reference:

Approvals:

Process Plan:

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Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop


**Sequence ID/
Work Center ID**
**Operation
Description**
**Set Up/
Run Hours**
**Draw
Number**
**Draw
Rev.**
**Plan
Code**
**Accept
Qty**
**Reject
Qty**
**Reject
Number**
**Insp.
Stamp**

190



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

09/10/2009

MF 09-10-21

Picklist Print

October 21, 2009 7:20:14 AM

Page 1

Work Order ID: 53004



Parent Item: D3136-041RevE



Parent Item Name: Window Assembly

Start Date: 10/21/09

Required Date: 10/21/09

Comments:

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3108-9RevB1		Manufactured	No			100	Each	816.0000	12.0000			

Decal

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST	816
34554	316
46546	500

BB 07/10/21
X12

MACRLICS.125 Purchased No 170 sf 228.8491 26.8421



1/8" Polycast II Sheet

Warehouse Loc Qty Loc Code

Location

Main Warehouse

MAT	228.8491
110115	4
110633	17.2295
111711	67.7447
112888	139.8749

112888

BB 07/10/21

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	53004
Description: Window Assembly	Part Number:	D3136-1
Inspection Dwg: D3136	Rev: E	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	<u>BR</u>	Audited by:	<u>S</u>	Prototype Approval:	N/A
Date:	9-10-01	Date:	02/02/01	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	09.05.04	New Issue	P/O D3136-041	KJ/DD  

